

19-7807



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18618-1
Job Sheet 200907

**Part No:** RBT18618-1**Job Qty:** 4 pcs**Part Name:** Wrench**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 9/19/19**Job Tracking No:****Due Date:** 11/11/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:** *ORDER INGO***Note:** DWG RBT18618 Rev 2 IPP Rev. A 19.09.18 New issue DP Verify DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
100	Waterjet - Omax - 1	4 pcs	11/11/19	11/11/19	0.17	0.80	Waterjet - Omax	<i>09/19/10/10</i>
110	QC 2	4 pcs	11/11/19	0.00	0.00		QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	<i>09/19/10/10</i>
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

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120	NV5000 - 1 - B4B	4 pcs	11/11/19	1.00 4.00	QC 2 - 5		
					QC 2 - 71		
					QC 2 - 73		
					QC 2 - 69		
130	QC 2	4 pcs	11/11/19	0.00 0.00	NV5000 - 1 - B4B	ALA / MK	19-11-5
					NV5000 - 2 - B4B		
					QC 2 - 1		
					QC 2 - 12		
					QC 2 - 14	ALA / MK	19-11-5
					QC 2 - 17		
					QC 2 - 19		
					QC 2 - 2		
					QC 2 - 20		
					QC 2 - 22		
					QC 2 - 23		
					QC 2 - 25		
					QC 2 - 32		
					QC 2 - 33		
					QC 2 - 35		
					QC 2 - 39		
					QC 2 - 4		
					QC 2 - 40		
					QC 2 - 44		
					QC 2 - 45		
					QC 2 - 48		
					QC 2 - 49		
					QC 2 - 50		
					QC 2 - 51		
					QC 2 - 52		
					QC 2 - 57		
					QC 2 - 62		
					QC 2 - 63		
					QC 2 - 8		
					QC 2 - 66		
					QC 2 - 64		
					QC 2 - 65		
					QC 2 - 5		
					QC 2 - 71		
					QC 2 - 73		
					QC 2 - 69		
140	QC 8	4 pcs	11/11/19	0.00 0.00	QC 8 - 12		
					QC 8 - 14		
					QC 8 - 17		
					QC 8 - 20		
					QC 8 - 25		
					QC 8 - 3		
					QC 8 - 32		
					QC 8 - 33		
					QC 8 - 35		
					QC 8 - 39		
					QC 8 - 4		
					QC 8 - 44		
					QC 8 - 45		
					QC 8 - 49		
					QC 8 - 58		
					QC 8 - 8	ALA 19-11-07	
					QC 8 - 9		
					QC 8 - 68		
					QC 8 - 67		

					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					GRO002-VC	2019-11-07
150	Outsource - 12 - Black Oxide	4 pcs	11/11/19			
160	Packaging 2-1 - Receive - B4B	4 pcs	11/11/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	NOV 15 2019
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
170	QC 6	4 pcs	11/11/19	0.00 0.00	QC 6 - 9	DAS
					QC 6 - 68	NOV 15 2019
					QC 6 - 61	68
					QC 6 - 40	9-89
					QC 6 - 81	
180	Packaging 3-1 - Stock - B4B	4 pcs	11/11/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	

				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	4 pcs	11/11/19	0.00 0.00	QC 21 - SA - 21	DAS 21 NOV 19 2019
				QC 21 - SA - 70	

Part Op 100 - 1-Cut as per DWG. DWG. Rev: 2 PROG. Rev: 2 2-Deburr if necessary 3-Apply LPS-3 to ALL steel

Descriptions: parts

110 - QC2- Inspect parts off machine FAI/FAIB

120 - 1-Machine as per folio F DWG FOLIO REV: AA

130 - QC2- Inspect parts off machine FAI/FAIB

140 - QC8- Inspect parts - second check

150 - -Issue P/O: 45032 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-

16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type;

1018 -Certificate of Conformity is required

160 - (Receive & Inspect for Damage & Mat'l Certs) -Certificate of Conformity is required

170 - QC6- All purchased or subcontracted products

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-P-0.500	Hot Rolled Steel Plate 0.500" (44W)	.1880 sf (.047 ea)	100-Waterjet - Omax - 1	5171947

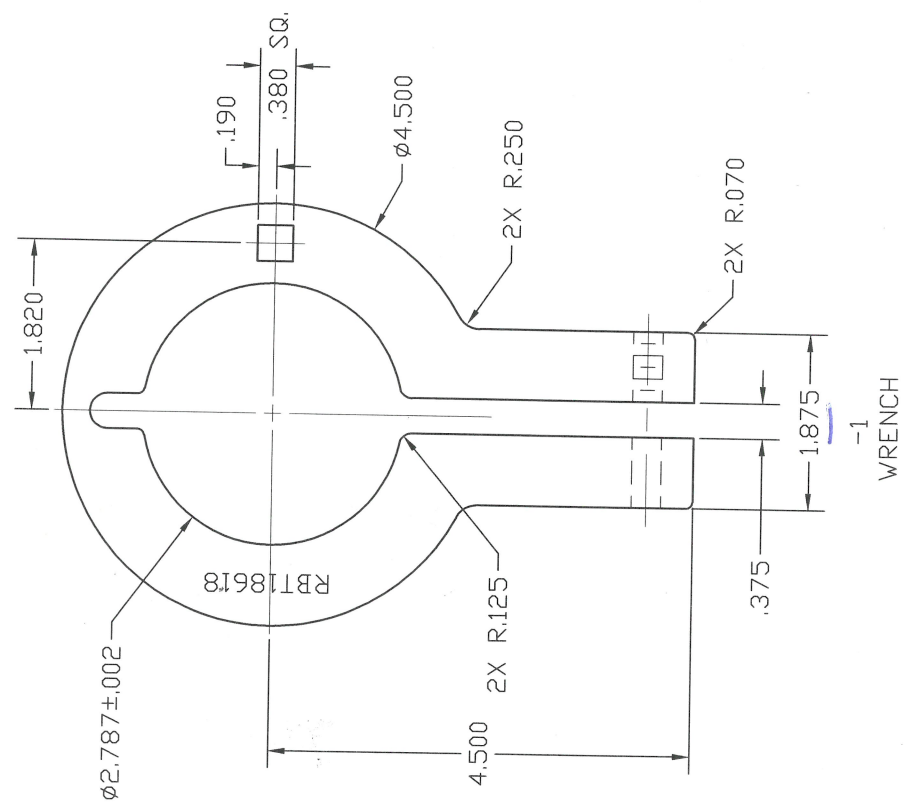
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	MT-HRS-P-0.500	0	31	0

Part Specifications

Specifications could not be found.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CH'D TITLEBLOCK & REVISION BLOCK. ADDED ENGRAVE NOTE 1 CH'D ASSY VIEW TO -A WELDMENT & ADDED TO BOM. CH'D -1 FROM 2.787±.002 TO ACCOMMODATE BOTH STEEL & ALUMINUM CLUTCH KNURED NUTS PER D.W., DELETED -9 FROM BOM.	1/15/10	RJC
2	CH'D -1 WRENCH TO ONE PIECE DESIGN PER D.W.	3/16/12	RJC



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SUBJECT TO AGREEMENT
WITH MANUFACTURE
2009 07 MJS
15 08-19

TITLE		REV	
RED BARN MACHINE		2	
DWG NO.		RBT18618-1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: COLE	
TOLERANCES ON DECIMALS		APPROVED: D. Weil	
.XXX ± .005		MATERIAL: BLACK OXIDE	
XX ± .01		FINISH: USED ON MODEL	
X ± .1		ANGLES ± 5°	
FRACTIONS ± 1/32		MATERIAL: MD 500 C	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R		MATERIAL: MD 500 D	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		DATE: 3-25-02	
SCALE: NTS		SHEET 2 of 2	



Dart Aerospace Ltd.
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K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER POHB045032



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045032

PO Date: 11/7/19

Due Date: 11/15/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200907	RBT18618-1	RBT18618 Rev 2	Wrench -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/15/19	4 pcs	0 pcs	4 pcs	\$9.75/pcs	\$39.00
2	200885	RBA9829-3	RBA9829 Rev 3	Wrench -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/15/19	5 pcs	0 pcs	5 pcs	\$5.95/pcs	\$29.75

NOV 15 2019

NOV 15 2019



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PURCHASE ORDER

POHB045032



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	201074	RBE117-12020W16-3	RBE117-12020W16 Rev B	Extractor -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed x6	-	11/15/19	6 pcs	0 pcs	6 pcs	\$3.75/pcs	\$22.50
4	200575	RBW6205G25331-3G-1	RBW6205G25331-3G Rev C	Puller -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed x8	-	11/15/19	8 pcs	0 pcs	8 pcs	\$4.15/pcs	\$33.20
5	200901	RB23005023-4	RB23005023 Rev 1	Swivel Head Screw ***Note***Foot needs to be re plated with the screw. -Issue P/O; -Chemically strip zinc plating from screw and foot. -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 12L14 Steel -Certificate of Conformity is required	Firmed x4	-	11/15/19	4 pcs	0 pcs	4 pcs	\$14.65/pcs	\$58.60



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PURCHASE ORDER **POHB045032**



Items													
Line Item	Job	Part		Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	200364	RB500N9506-1M-3		RB500N9506-1M Rev 5	Guide -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed XS	-	11/15/19	5 pcs	0 pcs	5 pcs	\$1.40/pcs	\$7.00
NOV 15 2019													
Grand Total:													\$190.05

NOV 15 2019

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/11/19 8:58 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(023954-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

023954 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
13-Nov-2019		Jigar Patel			POHB045032			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT18618-1 Rev.2	RBT18618 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0
2	RBA9829-3 Rev.3	RBA9829 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	5	5	0	0	0
3	RBE117-12020W16-3 Rev.B	RBE117-12020W16 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	BLACK-OXIDE CH	6	6	0	0	0
4	RBW6205G25331-3G-1 Rev.C	RBW6205G25331-3G 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	8	8	0	0	0
5	RB23005023-4 Rev.1	RB23005023 STRIP ZINC PLATING OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0

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NOV 14 2019

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DAS 68 9-29

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NOV 14 2019
DART AEROSPACE LTD.

**Certificat de conformité / Certificate of Compliance**
(023954-1)

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Tel: 514-335-3666 Fax: 514-335-3868
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Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courrier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
13-Nov-2019		Jigar Patel				POHB045032			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
6	RB500N9506-1M-3 Rev.5	RB500N9506-1M 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS		OXIDE-BLACK CH	5	5	0	0	0
7	STRIPPING CHARGES Rev.	STRIPPING CHARGES 01 -STRIP [STRIP]		STRIP LOT	4	4	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.

Entered: 2R Date: Dec 31/19
NCR No. 19-7807



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: <u>200907</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>R8718618-1</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐			
Date: <u>10/28/2019</u>	Sequence #: <u>120</u>	QTY Affected: <u>4</u>		MRB (QS1042) <u>AP</u>			
Description Work Order Deviation		Disposition					
MISSING THREAD DIMENSION: 5/16"-18 MISSING CLEARANCE HOLE DIMENSION: $\phi 0.332$ CENTERLINE OF BOTH HOLES IS 0.50" FROM BOTTOM OF PART.		THIS DEVIATION IS ACCEPTABLE THE FIT, FORM, AND FUNCTION OF THE PART WILL BE AS ORIGINALLY INTENDED.					
Root Cause		QC / QA Coordinator <u>DAS</u> <u>9</u> <u>9-89 19-11-21</u>					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☒		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabelled ☐ Other/Details:				Fault Category	
		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	